



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4091-1
Job Sheet 186655



Part No: D4091-1

Job Qty: 20 ea **DAS**

Part Name: Mounting Lug



36 **21**
9-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg D4091 Rev. A IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs	12/7/18	12/7/18	0.00	0.00	Purchasing		NOV 21 2018
110	Packaging	20 pcs	12/7/18	12/7/18	0.00	0.00	Packaging2		NOV 21 2018
130	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC6		61
160	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC3		6
170	Packaging	20 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		NOV 22 2018
180	QC21-SA	20 Ea	12/7/18	12/7/18	0.00	0.00	QC21		6

Part Op Descriptions: 100 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

NOV 20, 2018 x 20 *RLH*

DAS
21
9-89
NOV 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	4.5036 - 2.5020 ft (.1251 ea)	100-Purchasing	5/29 804
D4091-1P	Lug	20 pcs (1 ea)	100-Purchasing	5/29 802

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2423	3	233	0
	D4091-1P	20	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches ± 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches ± 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches ± 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches ± 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches ± 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches ± 0.010	0.303		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>		Pressure/Forced	☐	Temperature/Cure	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage/Defect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete	☐	Marks/Chatter	☐	Drill Holes	☐
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 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S129805



			0.283	
7	Mounting Lug	0.735Inches $\pm$ 0.010	0.745 0.725	Reference
8	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
9	Mounting Lug	3.700Inches $\pm$ 0.010	3.710 3.690	
10	Mounting Lug	0.625Inches $\pm$ 0.010	0.635 0.615	
11	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Mounting Lug	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter
13	Mounting Lug	0.400Inches $\pm$ 0.030	0.430 0.370	Radius
14	Mounting Lug	2.310Inches $\pm$ 0.010	2.320 2.300	Reference

Plex 11/19/18 3:09 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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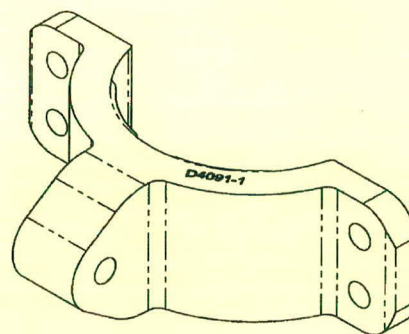
DART AEROSPACE LTD		Work Order: 186655
Description: Mounting Lug		Part Number: D4091-1
Inspection Dwg: D4091	Rev: a	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030					
4.45	+/-0.030					
0.27 REF	+/-0.030					
1.91	+/-0.030					
0.69	+/-0.030					
0.293	+/-0.010					
0.735 REF	+/-0.010					
0.375	+/-0.010					
3.700	+/-0.010					
0.625	+/-0.010					
0.375	+/-0.010					
Ø0.257	+0.006/-0.001					
R0.40	+/-0.030					
2.310 REF	+/-0.010					

Measured by:		Audited by:		Preliminary Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.05	New Issue	KJ	



D4091-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186625 MLS
1871-19

RELEASED
2010-04-28
WP

NOTES:

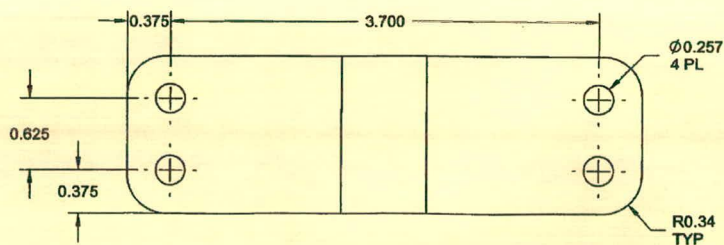
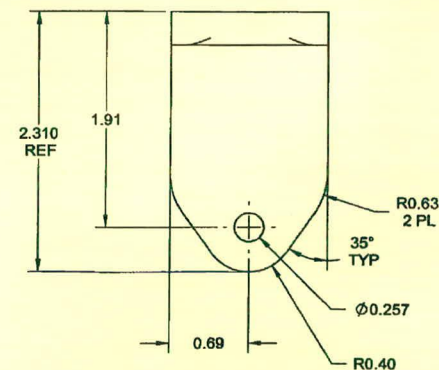
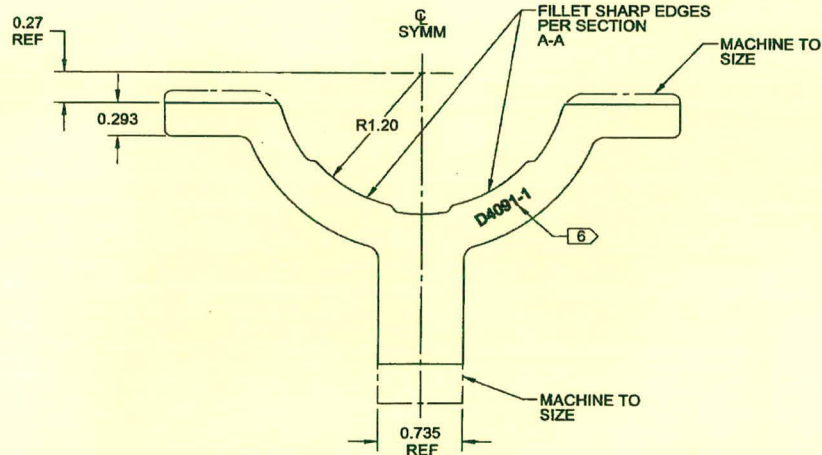
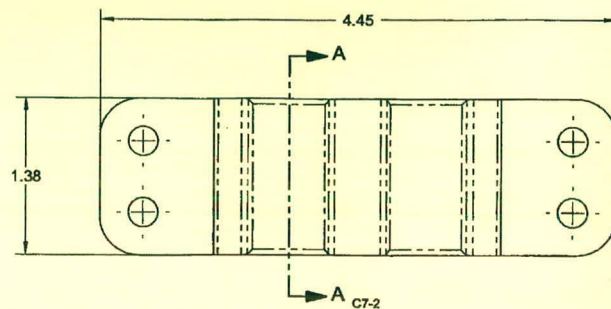
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	CP			SHEET 1 OF 2	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4091		SCALE	
MFG. APPR.	<i>[Signature]</i>	TITLE MOUNTING LUG		NTS	
APPROVED	<i>[Signature]</i>	DATE 10.03.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



R0.03-R0.07
TYP AROUND PAD

SECTION A-A
C5-2



D4091-1 MOUNTING LUG

RELEASED
2010-04-20

DESIGN	OP	DART AEROSPACE LTD	REV. A
DRAWN	OP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4091	SHEET 2 OF 2
MFG. APPR.		TITLE MOUNTING LUG	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DE APPR.		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.29		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041776**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041776
PO Date: 11/20/18
Due Date: 12/7/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186655	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	12/7/18	36 pcs	0 pcs	36 pcs	\$17.40/pcs	\$626.40

36 x NOV 21 2018

DAS
61
9-89

Line Item Note PLEASE SUPPLY ASAP PAINTED

Grand Total: \$626.40

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 11/20/18 10:59 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24261
Shipment Date: 20-Nov-2018
Ship Via: Pick up at METEC
Order Number: 3214
Order Date: 11/20/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041776
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	36	36	0	0	EA	DART-D4091-1P Lug alodined and painted as per QSI 005	A	3214-01

DAS
61
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

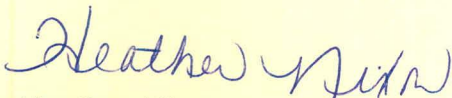
same

Quantity	Part Number	Part Name	DAS 61 9-89	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
36 ✓	D4091-1 ✓	Lug		A	B148835	21095	41776 ✓

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, November 20, 2018

